

FIG.1

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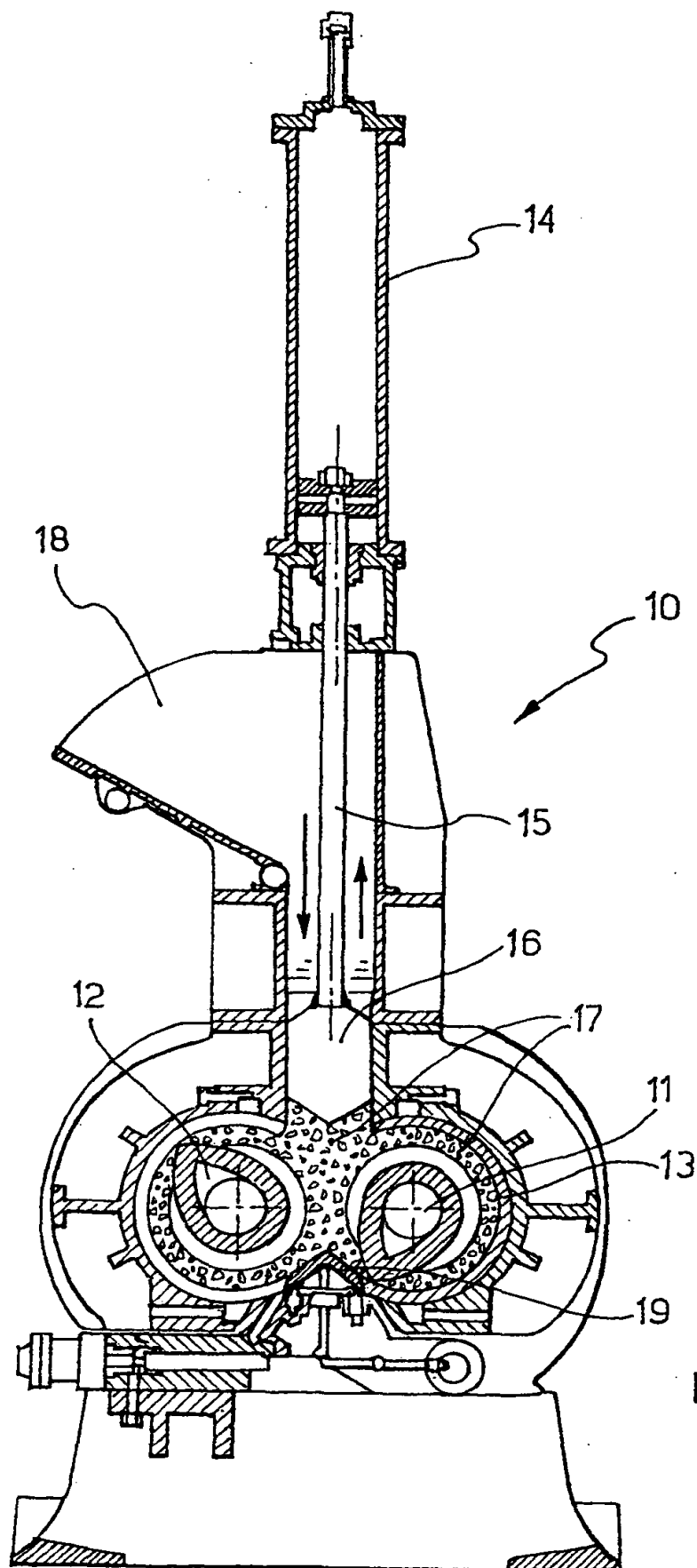


FIG. 2

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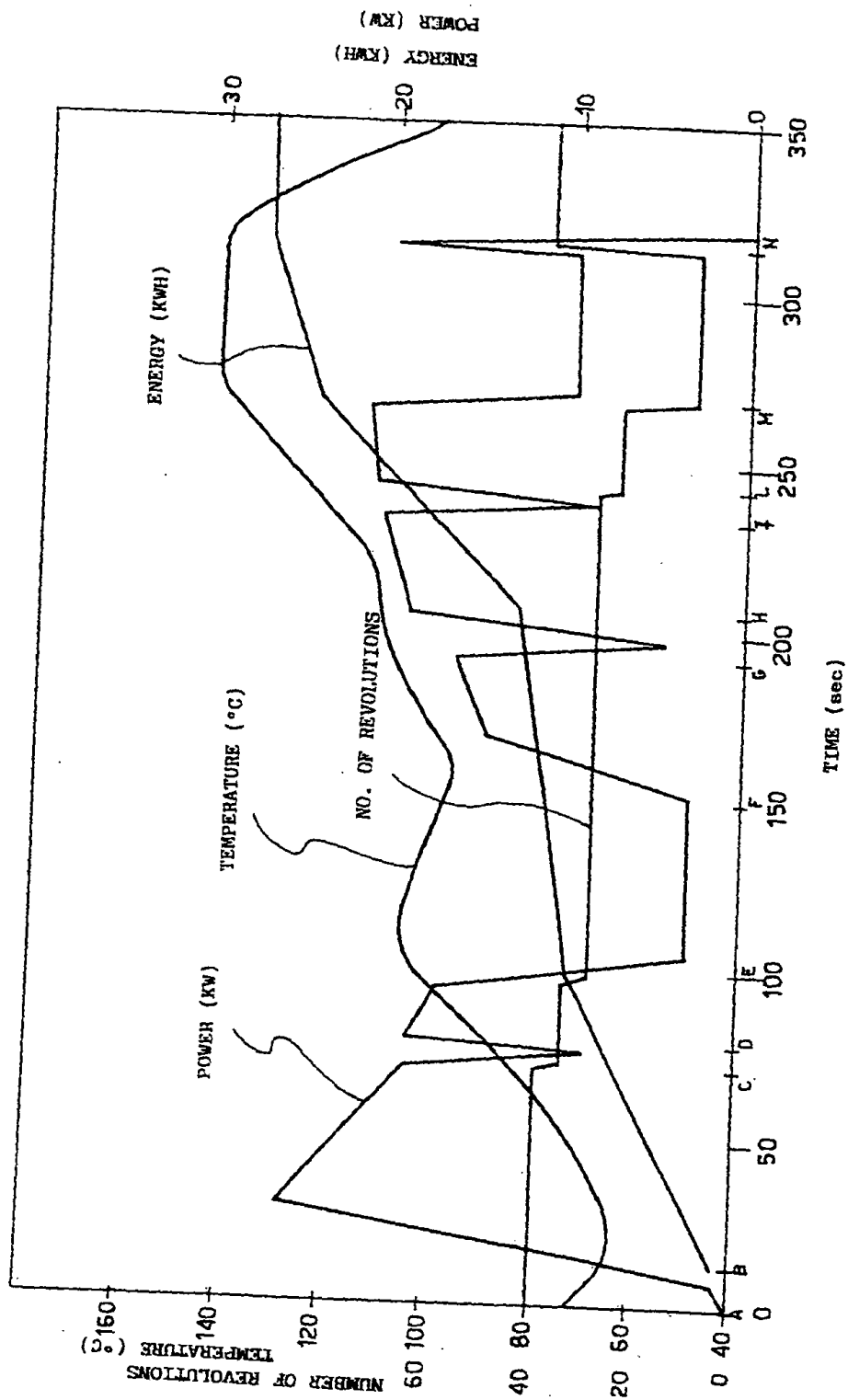


FIG. 3

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PROCESS PARAMETERS	EXPECTED PROCESS PARAMETERS AND ASSOCIATED TOLERANCES				NON-COMPLI- CY WEIGHING				EXAMPLE OF CHECK FOR COMPLIANCE OF PROCESS PARAMETERS OF A BATCH WITH PREDEFINED LIMIT VALUES				BASIS: TOTAL SCORE
	MIXTURE				STEP NO.	Set value	Tol.-	Tol.+	WEIGHT	MIXTURE			
	ACTUAL VALUE WITHIN LIMITS?			STEP NO.						ACTUAL VALUE WITHIN LIMITS?	SCORE		
STEP TIME (sec)	H-I	30	0		8	5	H-I	48 sec	NO			5	
PARTIAL TEMPERATURE (°C)	I	120	0	5	5	I	120 °C	YES	0				
PARTIAL ENERGY (KWH)	I	17.5	1.5	1.5	5	I	19.7 KWH	NO	5				
STEP TIME (sec)	L-M	25	5	5	7	L-M	42 sec	NO	7				
PARTIAL TEMPERATURE (°C)	M	145	0	0	0	M	145 °C	YES	0				
PARTIAL ENERGY (KWH)	M	24.5	2.4	2.4	8	M	27.7 KWH	NO	8				
PARTIAL CYCLE TIME (sec)	N	315	45	125	10	N	470	NO	10				
TOTAL MIXING TIME (sec)	N	245	25	120	40	N	308	YES	0				
TOTAL ENERGY (KWH)	N	27.0	1.0	4.0	10	N	32.1	NO	10				
PARTIAL TEMPERATURE (°C)	N	145	4	4	10	N	144	YES	0				
					100				45				
									DEFECTIVE 2nd DEGREE				

Fig.4

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REFERENCE CLASSIFICATION	
<= 6 min	: NORMAL
> 6 min / 9 min	: DEFECTIVE 2 nd DEGREE
> 9 min	: REJECT

PROCESS PARAMETERS	DETECTED VALUE
MAINTENANCE TIME OF MIXTURE INSIDE THE EXTRUDER	11 min

▲ REJECT

FIG. 5

Fig. 6

